

Work Order ID 73684

Tuesday, September 13, 2011 10:21:49 AM



Page 1

Item ID: D2574

Accept



Setup Start



Revision ID:

Item Name: Saddle, Aft In 205

Stop



Start Date: 9/13/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 9/30/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

11-09-12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D2574

Rev E

100

0.00



HAAS CNC VERTICAL MACHINING #1

B.A 11/11/10
anz

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. *73684* Double check by: *SG* ☐ 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets ☐ 3-Machine Step No 3 per Folio FA051 and insp

12 *1*

(PTO)

110

0.00



CONVENTIONAL MILLING MACHINE

B.A 11/11/11
anz

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2573 & D2574

12 *0*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

B.A 11/11/10
anz

QC

Memo

0.00

Quality Control

12 *0*

Dart Aerospace Ltd

| W/O: 73654 | | WORK ORDER CHANGES | | | | | |
|------------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D 257 PAR #: Fault Category: machine's NCR: Yes No DQA: Date: 11/11/15
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ck Date: 11/11/16

| NCR: 11-977 | | WORK ORDER NON-CONFORMANCE (NCR) # 217.52 | | | | | | |
|-------------|------|--|-----------------------------|---|-------------------------|---------------------------|-------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 11/11/13 | 100 | didn't change correctly the .100 handle jog to .001 and plunge into the part, make a bigger hole for .257 hole flange. | 11/11/14 [Signature] | scrap and destroy replace Qty 1 Batch # B 74507 | 11/11/13 [Signature] | 11/11/14 [Signature] | 11/11/14 [Signature] | 11/11/14 [Signature] |
| | | R.C. operator error. (tool is correct, program is good) Good Part is good | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 73684

Tuesday, September 13, 2011 10:21:49 AM



Page 2

Item ID: D2574

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Aft In 205

Start Date: 9/13/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 9/30/2011 Req'd Qty: 12.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

130 QC8- Inspect parts - second check 0.00

0.00



QC

Memo

0.00

Quality Control

140 Chemical Conversion Coat per QSI005 4.1 0.00

0.00



HandFinish

Memo

0.00

Hand Finishing

150 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

0.00



Powdercoat

Memo

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

12:00

0.00

3200F

12:30

M118434

12x Ø M-L 11/11/14

12x Ø M-L 11/11/14

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 73684

Tuesday, September 13, 2011 10:21:49 AM



Page 3

Item ID: D2574

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Aft In 205

Start Date: 9/13/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 9/30/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

12 BL 11-11-14

170

Identify as per dwg & Stock Location: ST 434 0.00



Packaging

Memo

0.00

Packaging

SP 11-11-14

180

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

11/11/14

MF 11-11-14

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Tuesday, September 13, 2011 10:21:53 AM

Page 1

Work Order ID: 73684

Parent Item: D2574

Parent Item Name: Saddle, Aft In 205



Start Date: 9/13/2011

Required Date: 9/30/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev: I As Per RevE 06-01-27 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--|--------------|---------------|----------------|--------|
| D6101-005  Saddle Billet | | Manufactured | No | | | 110 | Each | 31.0000 | 1  | 12 | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| MAT | 8 | |
| 71721 | 8 | |
| MAT045 | 20 | |
| 73420 | 20 | |
| MAT046 | 3 | |
| 66966 | 3 | |

B74507 X ¹³12 and 11/16/08

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | |
|---|---------------------------|
| DART AEROSPACE LTD | Work Order: 73684 |
| Description: Saddle, Aft Inboard | Part Number: D2574 |
| Inspection Dwg: D2574 Rev. E | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

| | | | | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|----------------|----------------------------|--------|--------|-------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | | |
| A | 0.438 | 0.443 | | 0.440 | 0.440 | 0.440 | .440 | | |
| B | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| C | 3.495 | 3.505 | | 3.500 | 3.500 | 3.500 | 3.500 | | |
| D | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| E | 7.990 | 8.010 | | 8.002 | 8.002 | 8.002 | 8.001 | | |
| F | 0.490 | 0.510 | | 0.501 | 0.500 | 0.501 | .501 | | |
| G | 0.257 | 0.262 | | 0.259 | 0.259 | 0.259 | .259 | | |
| H | 0.375 | 0.380 | | 0.377 | 0.377 | 0.377 | .377 | | |
| I | 0.490 | 0.510 | | 0.501 | 0.501 | 0.501 | .500 | | |
| J | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.179 | | |
| K | 0.558 | 0.578 | | 0.569 | 0.569 | 0.569 | .568 | | |
| L | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.179 | | |
| M | 1.365 | 1.375 | | 1.370 | 1.370 | 1.370 | 1.370 | | |
| N | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | | |
| O | 4.119 | 4.129 | | 4.124 | 4.124 | 4.124 | 4.124 | | |
| P | 0.115 | 0.135 | | 0.125 | 0.125 | 0.125 | .125 | | |
| Q | 0.115 | 0.135 | | 0.135 | 0.135 | 0.135 | .135 | | |
| R | 0.240 | 0.260 | | 0.250 | 0.250 | 0.250 | .249 | | |
| S | 0.115 | 0.135 | | 0.127 | 0.128 | 0.128 | .128 | | |
| T | 0.178 | 0.198 | | 0.188 | 0.188 | 0.188 | .188 | | |
| U | 3.210 | 3.250 | | 3.230 | 3.230 | 3.230 | 3.230 | | |
| V | 0.230 | 0.250 | | 0.239 | 0.238 | 0.238 | .237 | | |
| W | 0.115 | 0.135 | | 0.134 | 0.132 | 0.131 | .131 | | |
| X | 0.307 | 0.312 | | 0.3095 | 0.3095 | 0.3095 | .3075 | | |
| Y | 0.760 | 0.765 | | 0.763 | 0.763 | 0.763 | .764 | | |
| Z | 0.352 | 0.372 | | 0.362 | 0.363 | 0.362 | .362 | | |
| AA | 0.470 | 0.530 | | 0.500 | 0.500 | 0.500 | .500 | | |
| AB | 0.615 | 0.635 | | 0.626 | 0.626 | 0.626 | .626 | | |
| AC | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | .063 | | |
| AD | 0.240 | 0.260 | | 0.247 | 0.247 | 0.247 | .247 | | |
| AE | 1.500 | 1.520 | | 1.512 | 1.5125 | 1.5125 | 1.511 | | |
| AF | 0.115 | 0.135 | | 0.135 | 0.135 | 0.135 | .135 | | |
| AG | 0.240 | 0.280 | | 0.275 | 0.275 | 0.275 | .275 | | |
| AH | 0.240 | 0.260 | | 0.247 | 0.247 | 0.247 | .247 | | |
| AI | 2.000 | 2.020 | | 2.0075 | 2.002 | 2.003 | 2.003 | | |
| AJ | 0.023 | 0.043 | | 0.033 | 0.033 | 0.033 | .033 | | |
| Accept/Reject | | | | | | | | | |

| | |
|-----------------|----------|
| Measured by: BA | aml |
| Date: 11/11/10 | 11/11/12 |

| |
|-------------------------|
| Audited by: [Signature] |
| Date: 11/11/14 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|-------------|
| A | | New Issue | RF | |
| B | 02.09.27 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | [Signature] |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|---|--|---------------------------|
| DART AEROSPACE LTD | | Work Order: 73684 |
| Description: Saddle, Aft Inboard | | Part Number: D2574 |
| Inspection Dwg: D2574 Rev. E | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

| | | | | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|----------------|----------------------------|--------|-------|-------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 15 | 26 | 27 | 28 | | |
| A | 0.438 | 0.443 | | .440 | .440 | .440 | .440 | | |
| B | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| C | 3.495 | 3.505 | | 3.500 | 3.500 | 3.500 | 3.500 | | |
| D | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| E | 7.990 | 8.010 | | 8.001 | 8.001 | 8.001 | 8.001 | | |
| F | 0.490 | 0.510 | | .501 | .501 | .501 | .501 | | |
| G | 0.257 | 0.262 | | .258 | .258 | .258 | .258 | | |
| H | 0.375 | 0.380 | | .376 | .376 | .376 | .377 | | |
| I | 0.490 | 0.510 | | .500 | .505 | .504 | .504 | | |
| J | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.179 | | |
| K | 0.558 | 0.578 | | .568 | .570 | .571 | .571 | | |
| L | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.179 | | |
| M | 1.365 | 1.375 | | 1.370 | 1.370 | 1.370 | 1.370 | | |
| N | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | | |
| O | 4.119 | 4.129 | | 4.124 | 4.124 | 4.124 | 4.124 | | |
| P | 0.115 | 0.135 | | .125 | .125 | .125 | .125 | | |
| Q | 0.115 | 0.135 | | .135 | .135 | .135 | .135 | | |
| R | 0.240 | 0.260 | | .248 | .248 | .249 | .249 | | |
| S | 0.115 | 0.135 | | .131 | .130 | .130 | .130 | | |
| T | 0.178 | 0.198 | | .188 | .188 | .188 | .188 | | |
| U | 3.210 | 3.250 | | 3.230 | 3.230 | 3.230 | 3.230 | | |
| V | 0.230 | 0.250 | | .236 | .239 | .236 | .237 | | |
| W | 0.115 | 0.135 | | .132 | .128 | .130 | .129 | | |
| X | 0.307 | 0.312 | | .310 | .308 | .308 | .310 | | |
| Y | 0.760 | 0.765 | | .763 | .764 | .764 | .764 | | |
| Z | 0.352 | 0.372 | | .362 | .358 | .360 | .360 | | |
| AA | 0.470 | 0.530 | | .500 | .500 | .500 | .500 | | |
| AB | 0.615 | 0.635 | | .626 | .626 | .626 | .626 | | |
| AC | 0.053 | 0.073 | | .063 | .063 | .063 | .063 | | |
| AD | 0.240 | 0.260 | | .246 | .247 | .247 | .248 | | |
| AE | 1.500 | 1.520 | | 1.511 | 1.5105 | 1.511 | 1.511 | | |
| AF | 0.115 | 0.135 | | .135 | .135 | .135 | .135 | | |
| AG | 0.240 | 0.280 | | .265 | .270 | .275 | .275 | | |
| AH | 0.240 | 0.260 | | .246 | .247 | .247 | .247 | | |
| AI | 2.000 | 2.020 | | 2.004 | 2.003 | 2.003 | 2.003 | | |
| AJ | 0.023 | 0.043 | | .033 | .033 | .033 | .033 | | |
| Accept/Reject | | | | | | | | | |

| |
|-------------------------|
| Measured by: <i>amf</i> |
| Date: 11/11/12 |

| |
|-----------------------|
| Audited by: <i>JA</i> |
| Date: 11/11/14 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|-----------|
| A | | New Issue | RF | |
| B | 02.09.27 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | <i>JA</i> |

| | |
|---|---------------------------|
| DART AEROSPACE LTD | Work Order: 73684 |
| Description: Saddle, Aft Inboard | Part Number: D2574 |
| Inspection Dwg: D2574 Rev. E | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

| | | | | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|----------------|----------------------------|--------|--------|-------|----|------|
| Dim | Min | Max | Go/No Go Gauge | A9 | 210 | 811 | A12 | | |
| A | 0.438 | 0.443 | | .440 | .440 | .440 | .440 | | |
| B | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| C | 3.495 | 3.505 | | 3.500 | 3.500 | 3.500 | 3.500 | | |
| D | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| E | 7.990 | 8.010 | | 8.001 | 8.001 | 8.001 | 8.001 | | |
| F | 0.490 | 0.510 | | .501 | .501 | .502 | .501 | | |
| G | 0.257 | 0.262 | | .259 | .259 | .259 | .259 | | |
| H | 0.375 | 0.380 | | .377 | .377 | .377 | .377 | | |
| I | 0.490 | 0.510 | | .505 | .503 | .503 | .503 | | |
| J | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.179 | | |
| K | 0.558 | 0.578 | | .572 | .570 | .571 | .570 | | |
| L | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.179 | | |
| M | 1.365 | 1.375 | | 1.370 | 1.370 | 1.370 | 1.370 | | |
| N | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | | |
| O | 4.119 | 4.129 | | 4.124 | 4.124 | 4.124 | 4.124 | | |
| P | 0.115 | 0.135 | | .125 | .125 | .125 | .125 | | |
| Q | 0.115 | 0.135 | | .135 | .135 | .135 | .135 | | |
| R | 0.240 | 0.260 | | .248 | .249 | .249 | .249 | | |
| S | 0.115 | 0.135 | | .129 | .129 | .130 | .131 | | |
| T | 0.178 | 0.198 | | .188 | .188 | .188 | .188 | | |
| U | 3.210 | 3.250 | | 3.230 | 3.230 | 3.230 | 3.230 | | |
| V | 0.230 | 0.250 | | .238 | .237 | .238 | .236 | | |
| W | 0.115 | 0.135 | | .126 | .131 | .131 | .131 | | |
| X | 0.307 | 0.312 | | .309 | .309 | .310 | .310 | | |
| Y | 0.760 | 0.765 | | .764 | .764 | .764 | .764 | | |
| Z | 0.352 | 0.372 | | .360 | .360 | .360 | .360 | | |
| AA | 0.470 | 0.530 | | .500 | .500 | .500 | .500 | | |
| AB | 0.615 | 0.635 | | .626 | .626 | .626 | .626 | | |
| AC | 0.053 | 0.073 | | .063 | .063 | .063 | .063 | | |
| AD | 0.240 | 0.260 | | .247 | .248 | .248 | .247 | | |
| AE | 1.500 | 1.520 | | 1.5113 | 1.5105 | 1.5113 | 1.511 | | |
| AF | 0.115 | 0.135 | | .135 | .135 | .135 | .135 | | |
| AG | 0.240 | 0.280 | | .275 | .275 | .275 | .275 | | |
| AH | 0.240 | 0.260 | | .248 | .247 | .248 | .247 | | |
| AI | 2.000 | 2.020 | | 2.004 | 2.003 | 2.003 | 2.003 | | |
| AJ | 0.023 | 0.043 | | .033 | .033 | .033 | .033 | | |
| Accept/Reject | | | | | | | | | |

| |
|-------------------------|
| Measured by: <i>SMF</i> |
| Date: 11/11/12 |

| |
|-----------------------|
| Audited by: <i>SA</i> |
| Date: 11/11/14 |

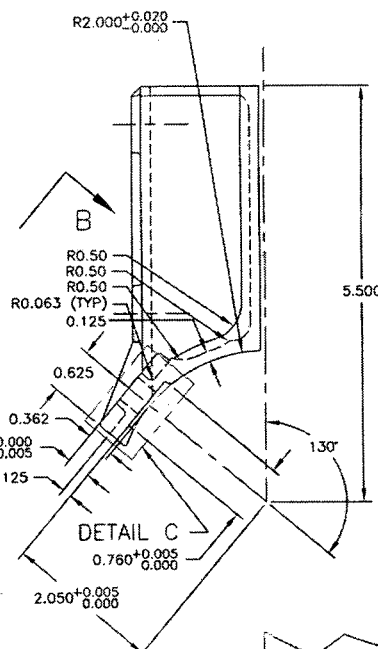
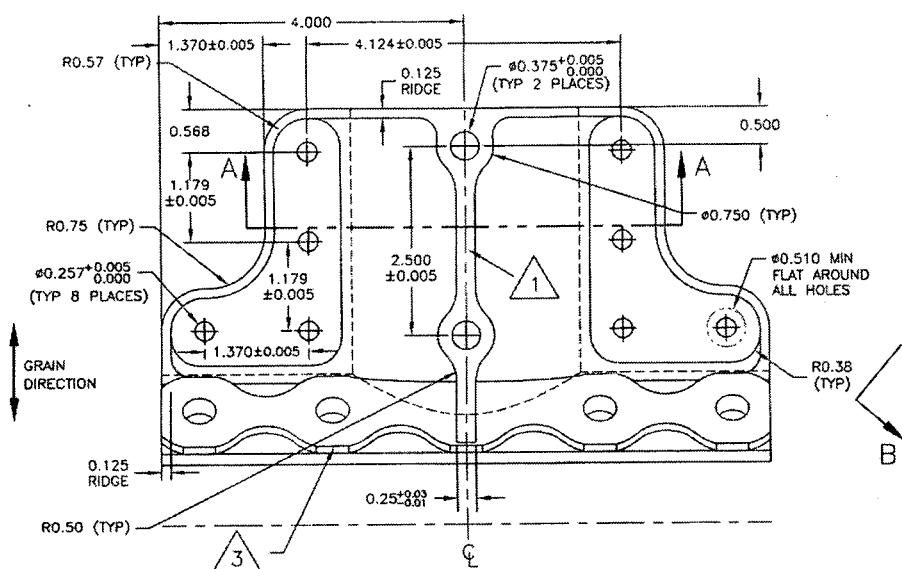
| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|-----------|
| A | | New Issue | RF | |
| B | 02.09.27 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | <i>SA</i> |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 23584
RELEASED
05.12.06

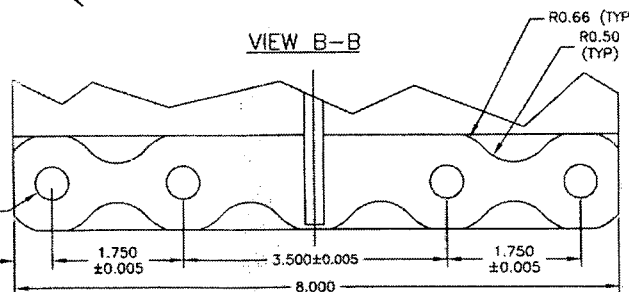
NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

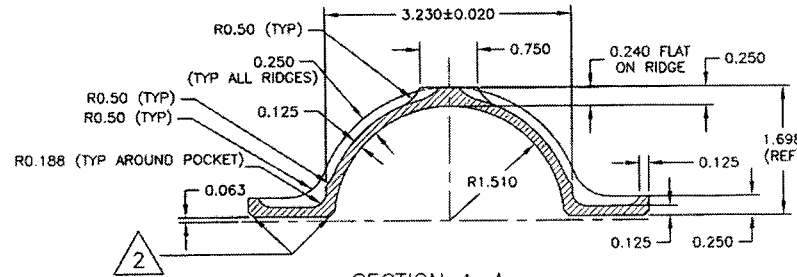
- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)



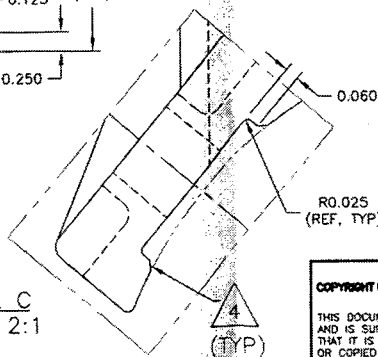
VIEW B-B



SECTION A-A



DETAIL C
SCALE 2:1



| | | |
|---|----------|--|
| E | 05.07.13 | ADD CHAMFER ON RIDGE NOTE 4 |
| D | 02.09.06 | ADD RIDGES; TIGHTEN TOLERANCES |
| C | 99.10.22 | INCPOR. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177 |
| B | 96.12.02 | ADD GRAIN DIR., 0.438 WAS 0.425 |
| A | 96.09.16 | NEW ISSUE |

| | | | | | |
|---------|----------|-------------|------------------|-------------|----------------------------|
| DESIGN | DS | DRAWN BY | PH | DART | DART AEROSPACE LTD. |
| CHECKED | ✓ | APPROVED | ✓ | | HORNSBURY, ONTARIO, CANADA |
| DATE | 05.07.13 | DRAWING NO. | D2574 | REV. E | SHEET 1 OF 1 |
| | | TITLE | INNER AFT SADDLE | SCALE | 2:1 |

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries